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**D022-661-011**  
**Job Sheet 203374**



Part No: D022-661-011

Job Qty: 1 pcs

Part Name: R22 Bearpaws



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/19

Job Tracking No:

Due Date: 12/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP Rev:C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM

Ship Via:

**Bill of Materials**

**Job Routing**

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                        |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Packaging 1 - Pick Kit | 1 pcs | 12/3/19    |          | 0.00      | 0.00    | Packaging 1 - 1       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 2       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 3 ✓     |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 4       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 5       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 6       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 7       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 8       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 9       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 10      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 11      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 12      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 13      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 14      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 15      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 16      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 17      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 18      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 19      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 20      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 21      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 22      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 23      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 24      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 25      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 26      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 27      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 28      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 29      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 30      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 31      |           |          |

Oscar

NOV 23 2019

DAS  
28  
9-89



Container No: S234445



Part: D022-661-011

Job No: 203374

Serial No/Batch: S234445

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH02-9 Issue 1;

|                                                                                                                                                                                                                                                 |       |         |           |                        |                                |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------|---------|-----------|------------------------|--------------------------------|
| 110 QC 4                                                                                                                                                                                                                                        | 1 pcs | 12/3/19 | 0.00 0.00 | Packaging 1 - 32       |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 1 - 33       |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 1 - 34       |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 1 - 35       |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 1 - 36       |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 28              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 58              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 69              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 9               |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 46              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 68              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 72              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 74              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 75              |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 4 - 78              | DAS<br>78<br>9-89 NOV 2 5 2019 |
| 120 Packaging 3-1 - Stock - B4B                                                                                                                                                                                                                 | 1 pcs | 12/3/19 | 0.00 0.00 | Packaging 3 - 1 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 2 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 3 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 4 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 5 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 6 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 7 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 8 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 9 - B4B  |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 10 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 11 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 12 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 13 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 14 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 15 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 16 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 17 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 18 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 19 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 20 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 21 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 22 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 23 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 24 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 25 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 26 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 27 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 28 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 29 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 30 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 31 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 32 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 33 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 34 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 35 - B4B |                                |
|                                                                                                                                                                                                                                                 |       |         |           | Packaging 3 - 36 - B4B | DAS<br>21<br>9-89 NOV 2 5 2019 |
| 125 DC - 1 - B4B                                                                                                                                                                                                                                | 1 pcs | 12/3/19 | 0.00 0.00 | DC - 1 - B4B           | DAS<br>21<br>9-89 NOV 2 5 2019 |
| 130 QC 21 - FG                                                                                                                                                                                                                                  | 1 pcs | 12/3/19 | 0.00 0.00 | DC - 2 - B4B           |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 21 - FG - 21        |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 21 - FG - 70        |                                |
|                                                                                                                                                                                                                                                 |       |         |           | QC 21 - SA - 53        | DAS<br>21<br>9-89 NOV 2 5 2019 |
| Part Op 100 - (Pick Kit)<br>Descriptions: 110 - (QC4- 100% Inspect kits for completeness) QC4- 100% Inspect kits for completeness<br>120 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D022-661-011 |       |         |           |                        |                                |

PKG

Location:

125 - (Document Control) Photocopy bluefile & type labels per PPPd022-661-011 CHG002

130 - (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

013048

Job BOM

| Part / Item   | Component Name                  | Quantity     | Operation                  | Container |
|---------------|---------------------------------|--------------|----------------------------|-----------|
| AN4-13A       | Bolt                            | 8 Ea (8 ea)  | 100-Packaging 1 - Pick Kit | 5228670   |
| D2182B028     | Rubber Cushion Black 2.8 " Long | 4 pcs (4 ea) | 100-Packaging 1 - Pick Kit | 5203400   |
| D2274         | Radius Block                    | 8 pcs (8 ea) | 100-Packaging 1 - Pick Kit | 5202685   |
| D2529         | Washer                          | 8 pcs (8 ea) | 100-Packaging 1 - Pick Kit | 5161059   |
| D2870         | Clamp                           | 2 Ea (2 ea)  | 100-Packaging 1 - Pick Kit | 26941     |
| D2871         | Clamp                           | 2 Ea (2 ea)  | 100-Packaging 1 - Pick Kit | 16838     |
| D3076-1       | R22 Bearpaw                     | 2 pcs (2 ea) | 100-Packaging 1 - Pick Kit | 5233212   |
| MS21042L4     | Nut                             | 8 Ea (8 ea)  | 100-Packaging 1 - Pick Kit | 5158232   |
| NAS1149D0463J | Washer                          | 8 Ea (8 ea)  | 100-Packaging 1 - Pick Kit | 5225595   |

Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 100-Packaging 1 - Pick Kit | AN4-13A        | 8        | 1,669     | 0         |
|                            | D2182B028      | 4        | 12        | 0         |
|                            | D2274          | 8        | 351       | 0         |
|                            | D2529          | 8        | 1,018     | 0         |
|                            | D2870          | 2        | 112       | 0         |
|                            | D2871          | 2        | 140       | 0         |
|                            | D3076-1        | 2        | 4         | 0         |
|                            | MS21042L4      | 8        | 5,383     | 0         |
|                            | NAS1149D0463J  | 8        | 7,014     | 0         |

Part Specifications

Specifications could not be found.

Plex 11/18/19 11:49 AM Dart.lajeunesse.marie

|                                                                                                                                                                                                                                                      |  |                   |                              |                                                                                                                                   |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|-------------------|------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------------|--|-------------------------------------------------------------------------------------------------------------------------|--|-------------------------------------------------|--------------------------------------------------------------------------------------------|--|--|
| NCR No. _____                                                                                                                                                                                                                                        |  | Route update only |                              |                                                                                                                                   |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
| Job: _____                                                                                                                                                                                                                                           |  |                   | DISPOSITION                  |                                                                                                                                   |  | DEPARTMENT/PROCESS                  |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
| Part No. _____                                                                                                                                                                                                                                       |  |                   | Rework<br>Scrap<br>Use-as-is |                                                                                                                                   |  | Skid-tube<br>Machining<br>Large Fab |                                                                                                                                               | Cross tube<br>Small Fab<br>Finishing |  | Eng. (Non-AW)<br>Prod. Eng. Coord.<br>Rec/Store/Packaging                                                               |  | Engineering<br>Water Jet<br>Supplier<br>Quality |                                                                                            |  |  |
| Date :                                                                                                                                                                                                                                               |  | Sequence #:       |                              | QTY Affected :                                                                                                                    |  | MRB (QS1042)                        |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
| Description Work Order Deviation                                                                                                                                                                                                                     |  |                   |                              | Disposition                                                                                                                       |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
| <div>Root Cause</div> <div><div>Operator</div><div>Manufacturing Process</div><div>Equip/Tooling</div><div>Handling/Presservation</div><div>Material</div><div>Product Improvement</div><div>Process Improvement</div><div>Human Factors</div></div> |  |                   |                              | FAULT CATEGORY                                                                                                                    |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
|                                                                                                                                                                                                                                                      |  |                   |                              | Pressure/Forced<br>Bending<br>Crushing<br>Cracks<br>Crimp/Kink/Ripple/Wave/Twist<br>Marks/Chatter<br>Mislabeled<br>Other/Details: |  |                                     | Contamination<br>Misaligned/off center<br>BOM/Route<br>Broken/Damage/Defect<br>Incomplete/Unclear Instructions<br>Drill Holes<br>Fit/Function |                                      |  | Power Loss/Surge<br>Folio/Program<br>Grain Direction<br>Weld<br>Wrong Stock Pulled<br>Out of Sequence<br>Off-set/Set-up |  |                                                 | Positioned Wrong<br>Outside Tolerance<br>Drawing<br>Finish<br>Part Lost/Missing<br>Misread |  |  |
|                                                                                                                                                                                                                                                      |  |                   |                              |                                                                                                                                   |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
|                                                                                                                                                                                                                                                      |  |                   |                              | Completed By                                                                                                                      |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
|                                                                                                                                                                                                                                                      |  |                   |                              | Lead hand / Supervisor                                                                                                            |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |
|                                                                                                                                                                                                                                                      |  |                   |                              | QC / QA Coordinator                                                                                                               |  |                                     |                                                                                                                                               |                                      |  |                                                                                                                         |  |                                                 |                                                                                            |  |  |

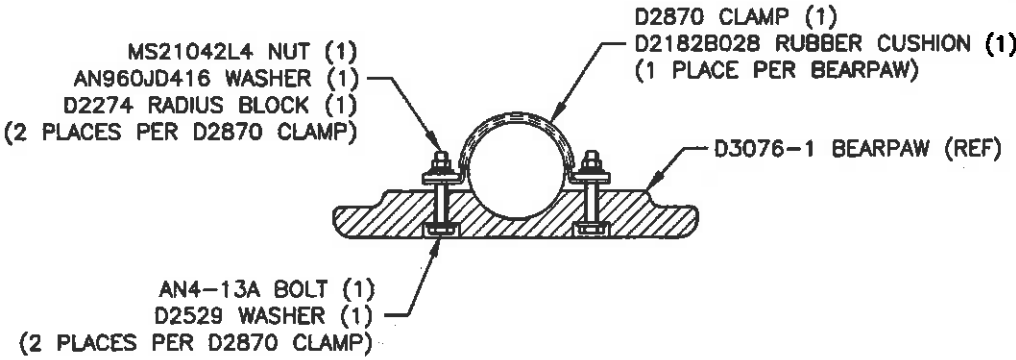


Figure 3 – Bearpaw Installation. Forward Clamp (section view)

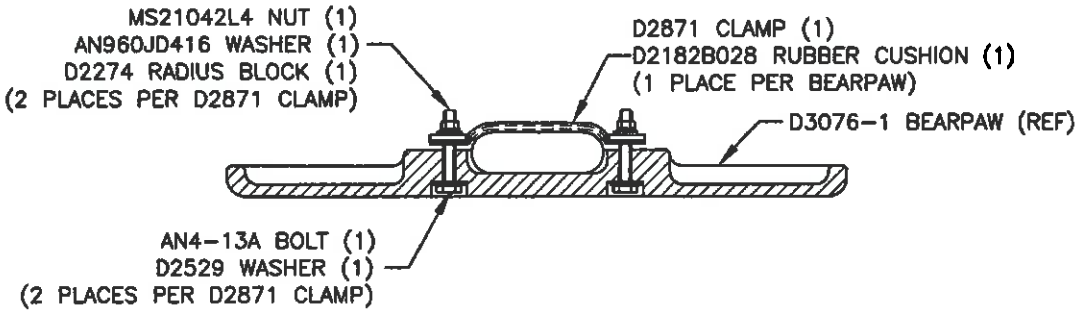


Figure 4 – Bearpaw Installation. Aft Clamp (section view)

4. WEIGHT AND BALANCE

| Installation                                               | Weight            | LATERAL         |                       | LONGITUDINAL       |                          |
|------------------------------------------------------------|-------------------|-----------------|-----------------------|--------------------|--------------------------|
|                                                            |                   | Arm             | Moment                | Arm                | Moment                   |
| D022-661-011 Bearpaw Installation<br>on model R22 aircraft | 4.6 lb<br>2.10 kg | 0.0 in<br>0.0 m | 0.0 lb-kg<br>0.0 m-kg | 121.1 in<br>3.08 m | 557.1 in-lb<br>6.47 m-kg |

5. PARTS LIST

| Qty | Part Number  | Description          |
|-----|--------------|----------------------|
| X   | D022-661-011 | BEARPAW INSTALLATION |
| 4   | D2182B028    | Rubber Cushion       |
| 8   | D2274        | Radius Block         |
| 8   | D2529        | Washer               |
| 2   | D2870        | Clamp                |
| 2   | D2871        | Clamp                |
| 2   | D3076-1      | Bearpaw              |
| 8   | AN4-13A      | Bolt                 |
| 8   | AN960JD416   | Washers              |
| 8   | MS21042L4    | Nut (or MS21042-4)   |